

Date: Friday, 15/02/2008 7:17:49 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 37371		Part Number	: D32833		
Estimate Number	: 10845		Drawing Number	: D3283 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 15/02/2008	S.O. No.	Type	: MACHINED PARTS		
Prsht Rev.	: NC		Drawing Revision	: E		
First Issue	: / /		Material	:		
Previous Run	: 37371		Due Date	: 22/02/2008		Qty: 40 Um: Each
Written By	:					
Checked & Approved By	:					
Comment	: Est A 04/09.28 New issue KJ/JLM Est Rev:B As per Rev E 07-09-09 JLM Verified By:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet Comment: Qty.: 0.3465 sf(s)/Unit Total : 13.8600 sf(s) 6061-T6 .080 Sheet Material: 6061-T6 (QQ-A-250/11) 0.080" thick (M6061T6S.080) Identify for D3283-3 Batch: <u>106320</u> HB 8-2-15
2.0	SHEAR	SHEAR Comment: SHEAR Cut blanks: 15.550" x 2.450 REV E HB 8-2-15
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Fello FA424 and Dwg D3283 Stack of 10 Identify as D3283-3 <i>W skr jet.</i> <i>2016 HB 8-2-18 P1</i> <i>Dwg D3283</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>HB 8-2-15</i> Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK Comment: SECOND CHECK <i>5 09/02/18 *40</i> <i>coantes</i>

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 37371

Part Number: D32833

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

Done at DCS & 3D Controls

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

508/02/19 x40

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08/02-20

40

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/02/20

40

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 177

8/2/21 50 40x

40

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Done 08/02/20

Job Completion



2008/2/21

40

W

Date: Monday, 2/11/2008 2:15:11 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	DOUBLER		
Job Number	37371			Part Number	D32833		
Estimate Number	10845			Drawing Number	D3283 REV E		
P.O. Number	:			Project Number	N/A		
This Issue	2/11/2008	S.O. No.	:	Drawing Revision	E		
Prsht Rev.	NC			Material	:		
First Issue	:/	Type	MACHINED PARTS	Due Date	3/10/2008	Qty:	40
Previous Run	26793			Um:	Each		
Written By	<u>11/08/02 11</u>						
Checked & Approved By							
Comment	Est A 04.09.28 New issue KJ/JLM						
	Est Rev:B As per Rev E 07-09-09 JLM Verified By:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet Comment: Qty.: 0.3465 sf(s)/Unit Total : 13.8600 sf(s) 6061-T6 .080 Sheet Material: 6061-T6 (QQ-A-250/11) 0.080" thick (M6061T6S.080) Identify for D3283-3 Batch: <u>Welded</u>
2.0	SHEAR	SHEAR Comment: SHEAR Cut blanks: 15.550" x 2.450
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA424 and Dwg D3283 Stack of 10 Identify as D3283-3
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:15:11 PM
User: Kim Johnston

Process Sheet

<input checked="" type="checkbox"/> Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: DOUBLER
Job Number: 37371		Part Number: D32833
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr		
7.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		
8.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
10.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
11.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

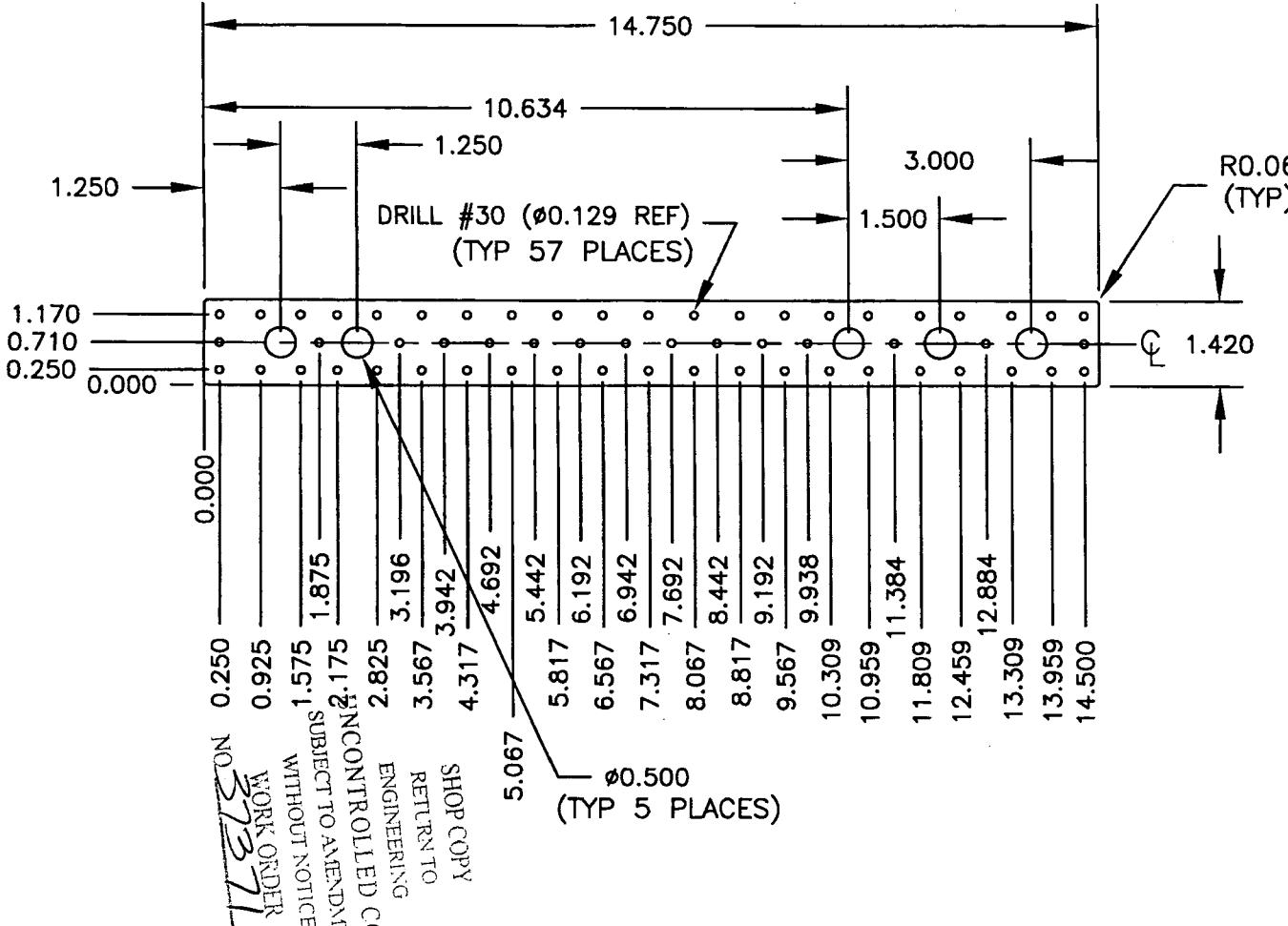
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.06.01
PER ECN 969

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. E
		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
		D3283	
DATE		TITLE	SCALE
07.06.01		DOUBLER	1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR - 1	
D	05.08.09	REDESIGN	
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	

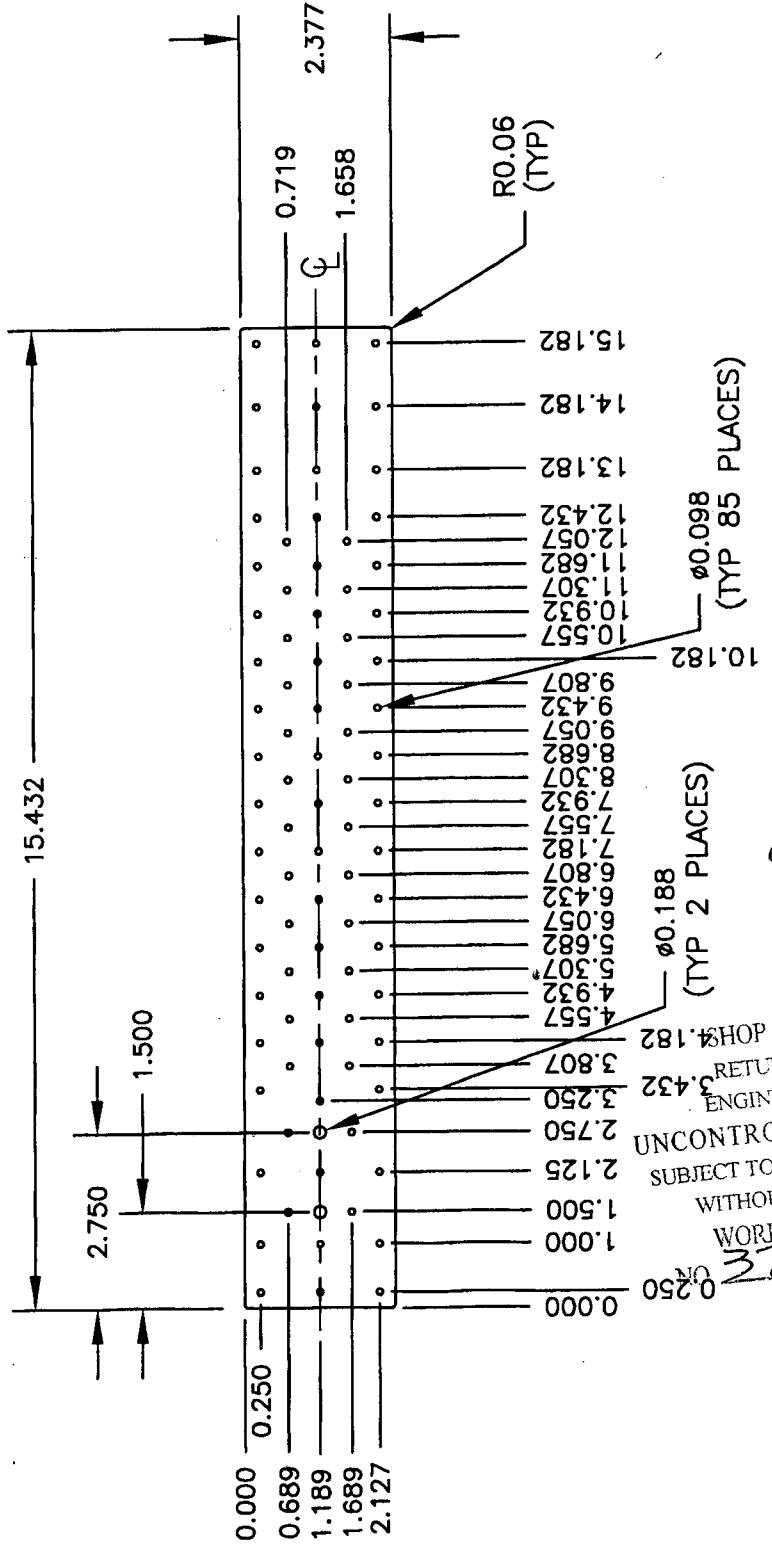
**D3283-1 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

DART

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>AB</i>	APPROVED <i>CH</i>	DRAWING NO. D3283	REV. E SHEET 2 OF 2
DATE 07.06.01	TITLE DOUBLER		SCALE 1:3

RELEASED
07-08-2014
PER ECN 969



D3283-3 DOUBLER
1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD

Work Order:

31371

Description: DOUBLER

Part Number:

D3283-3

Inspection Dwg: D3283-3 Rev: E

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+.004 - .001	.100	X			
Ø .188	+.005 - .001	.190	X			
.250	+/- .010	.250	X			
1.689	+/- .010	1.689	X			
1.189	+/- .010	1.189	X			
1.689	+/- .010	1.689	X			
2.127	+/- .010	2.127	X			
.719	+/- .010	.719	X			
1.658	+/- .010	1.658	X			
2.377	+/- .010	2.379	X			
2.750	+/- .010	2.750	X			
1.500	+/- .010	1.500	X			
.250	+/- .010	.250	X			
1.000	+/- .010	1.000	X			
1.500	+/- .010	1.500	X			
2.125	+/- .010	2.125	X			
2.750	+/- .010	2.750	X			
3.250	+/- .010	3.250	X			
3.432	+/- .010	3.432	X			
3.807	+/- .010	3.807	X			
4.182	+/- .010	4.182	X			
4.557	+/- .010	4.557	X			
4.932	+/- .010	4.932	X			

Measured by: HB
Date: 8-2-15

Audited by: J
Date: 08/02/15

Prototype Approval: /
Date: 1/2

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD

Work Order: 37371

Description: DOUBLER

Part Number: D3283-3

Inspection Dwg: D3283-3 Rev: F

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.307	+/- .010	5.307	X			
5.682	+/- .010	5.682	X			
6.057	+/- .010	6.057	X			
6.432	+/- .010	6.432	X			
6.807	+/- .010	6.807	X			
7.182	+/- .010	7.182	X			
7.557	+/- .010	7.557	X			
7.932	+/- .010	7.932	X			
8.307	+/- .010	8.307	X			
8.682	+/- .010	8.682	X			
9.057	+/- .010	9.057	X			
9.432	+/- .010	9.432	X			
9.807	+/- .010	9.807	X			
10.182	+/- .010	10.182	X			
10.557	+/- .010	10.557	X			
10.932	+/- .010	10.932	X			
11.307	+/- .010	11.307	X			
11.682	+/- .010	11.682	X			
12.057	+/- .010	12.057	X			
12.432	+/- .010	12.432	X			
13.182	+/- .010	13.182	X			
14.182	+/- .010	14.182	X			
15.182	+/- .010	15.182	X			
15.432	+/- .010	15.432	X			

Measured by: 62

Audited by: _____

Prototype Approval: _____

Date: 8-2-15

Date: _____

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	